Work Order I Monday, January 20			*111		Rus	A.	Page 1			
Revision ID:	40-11 set (Supersedes B67-43001-241)	2	Accept	*N900	1 040	100)* s	Setup Star		S1* S2*
Start Date: 1/20 Required Date: 1/31 Reference:	% Start Qty: 20.00 % Req'd Qty: 20.00	*20* *20*		Cust Item Customer						• • •
Approvals: Pro	ocess Plan:	Date: 14-1-20	Tooling:		Date:		F	Run Star	^I <i>V</i> I	R1*
QC	• •	Date:	SPC (Y/N):		Date:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description	esa s	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								,	
D3440	Rev A									
100 *1 00* Waterjet	FLOW WATER JET		0.00				20			Ae
FLOW CNC Waterjet		Dwg D3440 Dwg Rev:cessary	A Prog Rev: A	2-						14.01.
110	QC2- Inspect parts off.m	aehine FAI/FAIB	0.00							
110 QC Quality Control	Memo		0.00				20			14.01

120

QC8- Inspect parts - second check

0.00

120 ·

Memo

0.00 DAS 16 0.00 9-89 | | | | | | | | | | | | | | |

Quality Control

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_	_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	·r·					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orac	-					Rework			Skid-tube Crosstube	. []	Water Jet	\neg	Engineering
Part N	lo.					Scrap			Machining Small Fab	\vdash	Pro	d. Eng. Coor.	┪	Quality
	-					Use-as-is			noforming Finishing		4	e/Packaging	┨	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite]	Supplier		
Root				<u> </u>	Dosc	ription of work order update	Н	nitial	Action		Sign &		T	
Cause		Date	Step	Qty	Desc	or non-conformance	l	iiilliai iief Eng			Date	Verification		QC Inspector
Design	+	Date	Step	<u> </u>		of floir comormance	<u> </u>	iici Liig	Description		Dute	Vermedelon	┪	QC IIISPECTO
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Handling/Pre													1	
Material				ļ									ļ	
Operator														
Offset/Setup														
Process							l							
Supplier													1	
Training														
Transport														
Unapproved														
							FA	ULT CA	TEGORY					
Landir	ng G	iear			·	General		-		_	7	_	_	
	\blacksquare	Bending				Bend		4	Program	\perp	Outside Dim	}-	_	Pressure/Forced
		Centre No	ot Concei	ntric	<u> </u>	BOM/Route	<u>_</u>	Grain		-	Over/Under		_	Set-up
		Cracks	_		\vdash	Broken/Damage/Defect	\vdash	Hardwa		\vdash	Part Incorre		\neg	Temperature/Cure
		Crimp/Kii	nk/Ripple	e/Wave	<u> </u>	Burrs	<u> </u>	-d :	ion Incomplete/Unqualified	-	Part Lost/M	ssing	-	Weld
		Cuffs			_	Contamination	\vdash	4	tions Incomplete/Unclear	\vdash	Part Moved	. <i>.</i> L		Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	\vdash	-	gned/off center	-	Positioned V	_	_	Other
		Heat Trea		- .	<u> </u>	Cut Too Short	-	Mislab		L	Power Loss/	ourge [Other
		Inspectio	•	Tube	\vdash	Drawing		Misrea						
		Marks/Ch			\vdash	Drill Holes	-	Off-set						
		Turning S	-		-	Finish	\vdash	4	Calibration					
1		Wave/Tw	vist in Tul	oe		Fit/Function	1	Jout of	Sequence					

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W	ork	Order	ID	111723
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111723

Page 2

Monday, January 20, 2014 2:34:54 PM Item ID: D3440-11 Accept *N900040100* Setup Start **Revision ID:** Stop Gusset (Supersedes B67-43001-241) **Item Name: Start Qty: 20.00** *20* **Start Date:** 1/20/2014 **Cust Item ID: Required Date:** 1/31/2014 Req'd Qty: 20.00 *20* **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Reject Tool # Plan Accept Insp. Work Center ID Description Number Stamp Code Qty Qty **Run Hours** Identify as per dwg & Stock Location: Weg 2 130 $20 \times \frac{28}{28} 14-01-27$ *130* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 MUJ 14-01-27 *140* QC 0.00 Memo **Quality Control**

DQA:			Date:			·							TRACT
						WORK ORDER NON	-CC	ONFOR	RMANCE / U				AEROSPACE
QA Closed:			Date:							V	/ork Order up	date only	
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
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Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1	ł	noforming	Finishing		e/Packaging	Other
NCR I	No.					Suspected Unapproved	1		Large Fab	Composite		Supplier	
Root					Desc	ription of work order update	1	nitial		tion	Sign &	_	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Equip/Tooling													
Handling/Pre													
Material _	_												
Operator	\vdash						}					:	:
Offset/Setup	_		İ										
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Supplier Training												:	
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							FA	ULT CAT	TEGORY				
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		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concei	ntric		BOM/Route	L	Grain		L	Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci _	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	L	Burrs		Inspect	ion Incomplete/U	Jnqualified	Part Lost/Mi	_	Weld
	L	Cuffs				Contamination		4	tions Incomplete/	—	Part Moved	L	Wrong Stock Pulled
	L	Crushing				Countersink		1 1	gned/off center	_	Positioned V	· ·	٦
		Heat Trea			L	Cut Too Short		Mislabe		L	Power Loss/	Surge	Other
	_	Inspectio	•	Tube	\vdash	Drawing	\vdash	Misrea					-
	L	Marks/Ch			<u> </u>	Drill Holes	_	Off-set					
	\vdash	Turning S	•		<u> </u>	Finish	\vdash	4	Calibration				
	l	Wave/Tw	ist in Tul	эe		Fit/Function		Out of:	Sequence				

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Page 1

Work Order ID:

111723

Parent Item:

D3440-11

Parent Item Name:

Gusset (Supersedes B67-43001-241)

Start Date: 1/20/2014

Required Date: 1/31/2014

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 08-06-18 new issue DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X06.000		Purchased	No			100	f	126.6100	0.1719	4		1	
6061-T6 Bar .250 x 6.00									C			le 14	· 01.26
				Location		Loc Oty	Lo	c Code					
				MAT051		126.61							
				1210	940	0.15							
				1232	279	17.86							
				1253	886	23.86							
				1255	90	3.74							
				m12	6647	81			12	0647.	> (' 4 ')	

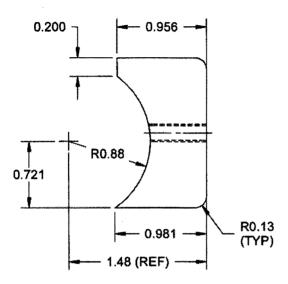
DQA:			Date:											7	
						WORK ORDER NON	-CC	ONFO	RMANCE / L				_	_	AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only		
Work Orde	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
	•					Rework	1		Skid-tube	Crosstube			Water Jet	٦	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	7	Quality
	•					Use-as-is	1	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo.					Suspected Unapproved]		Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		nitial	Ad	ction		Sign &		Т	•••
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Equip/Tooling									i						
Handling/Pre			1								Ì				
Material		i		į			İ								
Operator															
Offset/Setup				<u> </u>	İ										
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Transport														١	
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							FA	ULT CA	regory						
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,		Bending			_	Bend	\vdash	4	Program		\vdash	Outside Dim	F	→	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			-	Over/Under	-	→	Set-up
		Cracks			\vdash	Broken/Damage/Defect		Hardwa		11	ш	Part Incorred	⊢		Temperature/Cure
:	_	Crimp/Kir	nk/Ripple	:/Wave	_	Burrs	<u> </u>	4 .	ion Incomplete/l		\vdash	Part Lost/Mi	_	_	Weld
	_	Cuffs				Contamination	-	-1	tions Incomplete		\vdash	Part Moved			Wrong Stock Pulled
	<u> </u>	Crushing			<u> </u>	Countersink	\vdash	-	gned/off center	Γ	-	Positioned V		7	Other
	\vdash	Heat Trea		Tl	 	Cut Too Short	-	Mislabe			Ш	Power Loss/	onike [Other
ļ	\vdash	Inspectio		ıupe		Drawing Drill Holes	-	Misrea Off-set							
	\vdash	Marks/Ch Turning S			\vdash	Finish	\vdash	4	Calibration		•				
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Wave/Twist in Tube			istiii iut	L	prigranction	1	Jour of	Jequence							

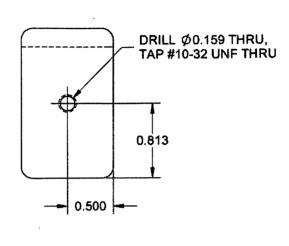
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- 1			
DESIGN	DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO. D3440	REV. A SHEET 5 OF 7
DATE 05	5.06.02	BLADE FOLD KIT PARTS	SCALE 1:1

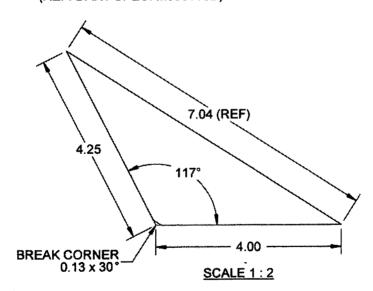




D3440-9 TUBE DETENT CLIP BASE SUPERSEDES PREMIER P/N B67-43001-241

1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS/QQ/A/200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)





D3440-11 GUSSET

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.250)

NOTES:

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	NFOI	RMANCE / UI		Wor	k Order up	date only	7	AEROSPACE
QA Closed.			Dute.									·		_1	
Work Orde	er:					DISPOSITION	N			AGAINST I	IST DEPARTMENT/PROCESS				
	-				_	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap		ı	Machining	Small Fab			d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	4	Rec/Stor	e/Packaging	_	Other
NCR N	NCR No.				Suspected Unapproved			Large Fab	Composite			Supplier			
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Handling/Pre	Щ														
Material	Ш														
Operator	Щ													1	
Offset/Setup	Ш		<u> </u>								1				
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	\vdash	Wave/Tw	-			Fit/Function		4	Sequence		_		*****		

DART AEROSPACE LTD	Work Order: 1/17	23
Description: Gusset	Part Number:	D3440-11
Inspection Dwg: D3440 Rev: A	P	age 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	X	Prototype
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	T		T	1	I	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.00	-		て	JKM-06
4.25	+/-0.030	4.25	-		て	
7.04	+1030	7.02	-		T	

Measured by: Ae	Audited by:	Prototype Approval:	N/A
Date: 14.01-26	Date: 6 July 27	Date:	N/A
	9-89 /		

Rev	Date	Change	Revised, by	Approved
Α	08.07.23	New Issue	KJ/DD 🛠	<i>X</i>

DQA:		Date:											
OA Classed			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only										
QA Closed:			Date:							V	OIR Older up	date only	
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
						Rework	1		Skid-tube	Crosstube	Water Jet		Engineering
Part N	lo.					Scrap	i I		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR No			Suspected Unapproved			Large Fab	Composite]	Supplier				
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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Equip/Tooling													
Handling/Pre													
Material	-		:										
Operator													
Offset/Setup			ļ										
Process													
Supplier	Н												}
Training Transport	Н									-			
Unapproved	H						l				1		
FAULT CATEGORY													
Landi	ng G	Gear				General		,					
	_	Bending				Bend	d Folio/				Outside Dimensions Pressure/Forced		
		Centre Not Concentric				BOM/Route		Grain		` [Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardware			Part Incorrect		Temperature/Cure
		Crimp/Kink/Ripple/Wave				Burrs		Inspection Incomplete/Unqualified		Jnqualified	Part Lost/Missing		Weld
		Cuffs				Contamination		Instructions Incomplete/Unclear		/Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misaligned/off center			Positioned V	Vrong	-
		Heat Treat				Cut Too Short		Mislabeled			Power Loss/Surge		Other
		Inspection Strip in Tube				Drawing		Misread					
		Marks/Chatter				Drill Holes		Off-set	Off-set				
		Turning Sequence				Finish		Out of	Out of Calibration				
		Wave/Twist in Tube				Fit/Function		Out of	Out of Sequence				